

Date: Monday, 23/03/2009 9:54:28 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOUBLER
<b>Job Number</b> :	46655		
<b>Estimate Number</b> :	12956		
<b>P.O. Number</b> :		<b>Part Number</b> :	D36392
<b>This Issue</b> :	23/03/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3639 REVA
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	42299	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	07/04/2009
<b>Written By</b> :		<b>Qty:</b>	6
<b>Checked &amp; Approved By</b> :	JLD 09.03.23	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A New Issue 07-07-20 JLM	<b>Verified By:</b>	EC

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S050	2024-T3 .050 sheet
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**Comment:** Qty.: 0.2510 sf(s)/Unit Total : 1.5057 sf(s)

2024-T3 .050 sheet

Batch:

11381

IB 9-4-24

~~10074~~

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3639

Dwg Rev: A

Prog Rev: A

IB 9-4-24

9

2-Deburr if necessary

IB 9-4-24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 9-4-24



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/04/24 (49)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

C'sink as per Dwg D3639

11/04/23

Permanent Change

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/03/2009 9:54:28 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 46655

Part Number: D36392

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3639

SB 09/04/29 (9)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

505/04/29 (x9)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 04-04-30 (9)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/30 (9)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

57244A

09/05/01 (9)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/01 (9)

Job Completion



MF  
09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>W16055</i>
<b>Description:</b> Doubler		<b>Part Number:</b> D3639-2
<b>Inspection Dwg:</b> D3639	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

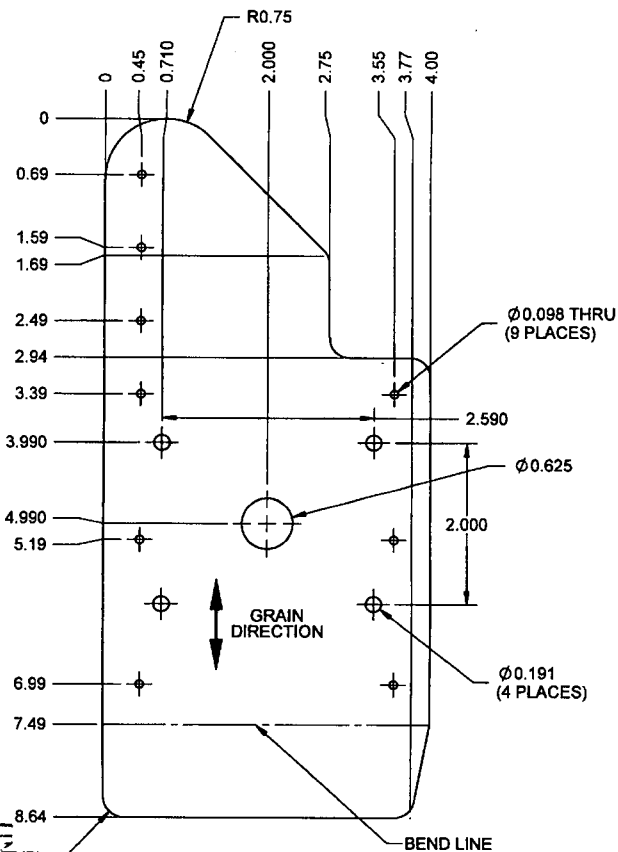
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Ø0.625	+0.008/-0.001	.626	x			
Ø0.191	+0.005/-0.001	.194	x			
Ø0.098	+0.004/-0.001	.100	x			
0.69	+/-0.030	.690	x			
1.59	+/-0.030	1.590	x			
2.49	+/-0.030	2.490	x			
3.39	+/-0.030	3.391	x			
3.990	+/-0.010	3.990	x			
4.990	+/-0.010	4.992	x			
5.19	+/-0.030	5.188	x			
6.99	+/-0.030	6.994	x			
8.64	+/-0.030	8.635	x			
0.45	+/-0.030	.444	x			
0.710	+/-0.010	.710	x			
2.000	+/-0.010	2.003	x			
2.75	+/-0.030	2.754	x			
3.55	+/-0.030	3.55	x			
4.00	+/-0.030	4.009	x			
2.000	+/-0.010	1.999	x			
2.590	+/-0.010	2.592	x			

<b>Measured by:</b> <i>AB</i>
<b>Date:</b> <i>9-4-24</i>

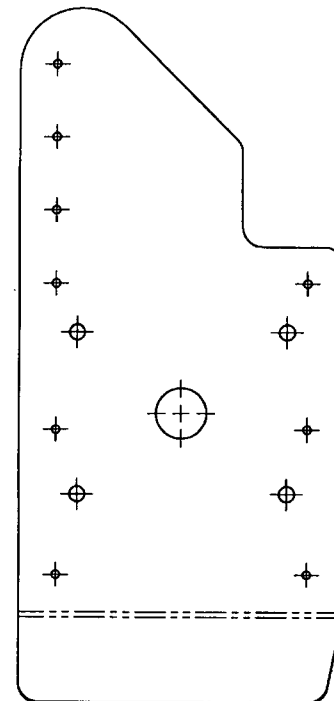
<b>Audited by:</b> <i>S</i>
<b>Date:</b> <i>09/04/24</i>

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD <i>[Signature]</i>	<i>[Signature]</i>



**D3639-1F FLAT PATTERN**  
**(D3639-2F OPPOSITE)**



**D3639-1 DOUBLER**  
**(WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE**  
**(WAS GENEVA P/N G10604-6)**

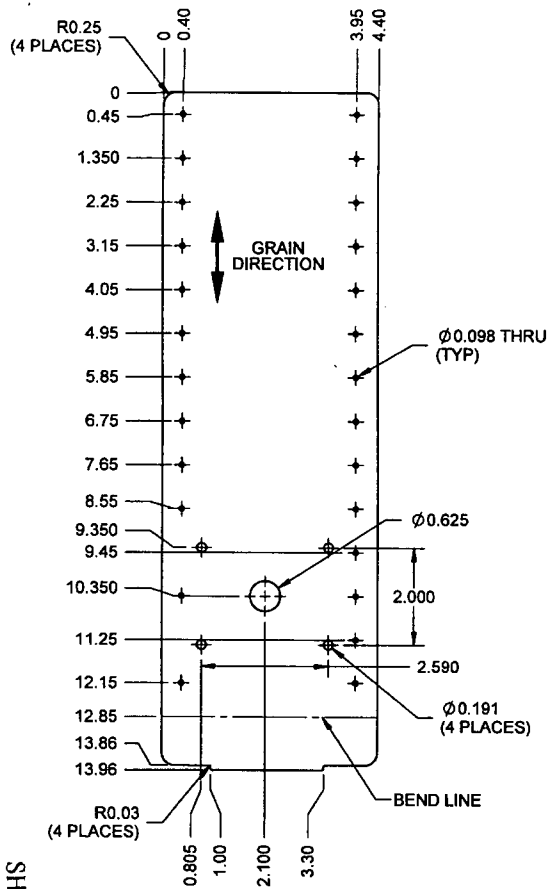


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07-07-07

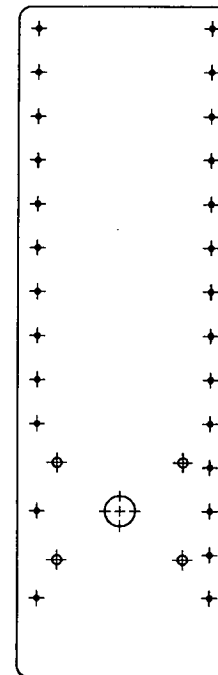
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WORK ORDER  
WITHOUT NOTE  
IN CONTROLLED  
ENGINEERING  
RETURN TO  
SHOP COPY

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.14 lbs

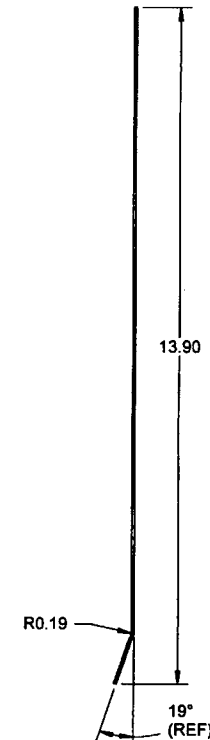
A	NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	LE			
CHECKED	TS	DRAWING NO.	REV. A	
MFG. APPR.	TS	D3639	SHEET 1 OF 2	
APPROVED	TS	TITLE	SCALE	
DE APPR.	TS	DOUBLER	2:3	
DATE	07.07.27			
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**D3639-3F FLAT PATTERN  
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER  
(WAS GENEVA P/N G10604-4)  
D3639-4 OPPOSITE  
(WAS GENEVA P/N G10604-5)**



**RELEASED**  
07.09.07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.3 lbs

NO WORK-PIECES  
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DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	NO	D3639	SHEET 2 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	NO	DOUBLER	2:5
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